

Date: Tuesday, 12/08/2008 1:01:13 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE BRACKET, GAS SPRING		
Job Number	: 41174		Part Number	: D2144		
Estimate Number	: 10179		Drawing Number	: D2144 REV. D		
P.O. Number	:		Project Number	: N/A		
This Issue	: 12/08/2008	S.O. No. :	Drawing Revision	: D		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 08/09/2008	Qty:	40
Previous Run	: 34465		Um:	Each		
Written By	:					
Checked & Approved By	: <u>1008-8-21</u>					
Comment	: Est: D 04.05.06 Reformat KJ/RF Est Rev:E Now on Waterjet 06-10-15 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
		 <b>Comment:</b> Qty.: 0.0945 sf(s)/Unit Total : 3.7800 sf(s) 304/316 .063 Sheet 16GA Batch: <u>108704 1B 8-8-21</u>
2.0	WATER JET	FLOW WATER JET
		 <b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D2144 Dwg Rev: <u>D</u> <u>1B 8-8-21</u> Prog Rev: <u>D</u>
		 <u>44</u> <b>Comment:</b> 2-Deburr if necessary <u>1B 8-8-21</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <u>1B 8-8-21</u> <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 <u>1B 8-8-21</u> <b>Comment:</b> SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <u>1B 8-8-21</u> <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary
		<u>Done at Step 22</u> <u>1008-8-21</u> <u>1008-8-21</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/08/2008 1:01:13 PM  
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Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144 Rev: D

SB 08/11/04 44

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

- 1- Weld corner as per Dwg D2144 & QSI 004
- 2- Grind flush

PL 08/11/25

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION



10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/11/04 44

11.0 POWDER COATING POWDER COATING



M 109 152



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:50

8:50

OVEN TEMPERATURE: 220

220

FINISH TIME: 9:20

9:20

M-1 08/11/27

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



HF



Comment: INSPECT POWDER COAT

08-11-27

44

13.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 198A

8/11/27

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/28 (J)

Job Completion



MF 08-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

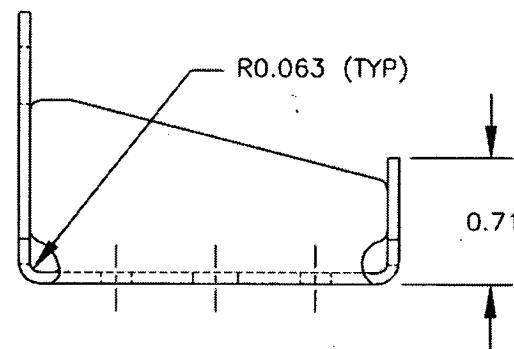
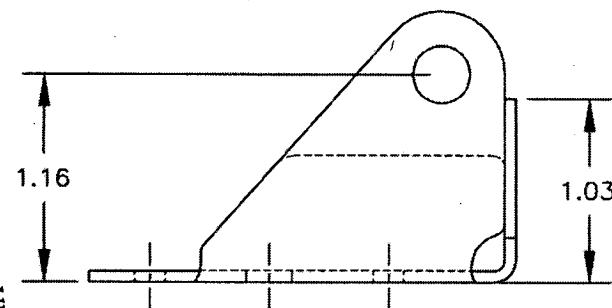
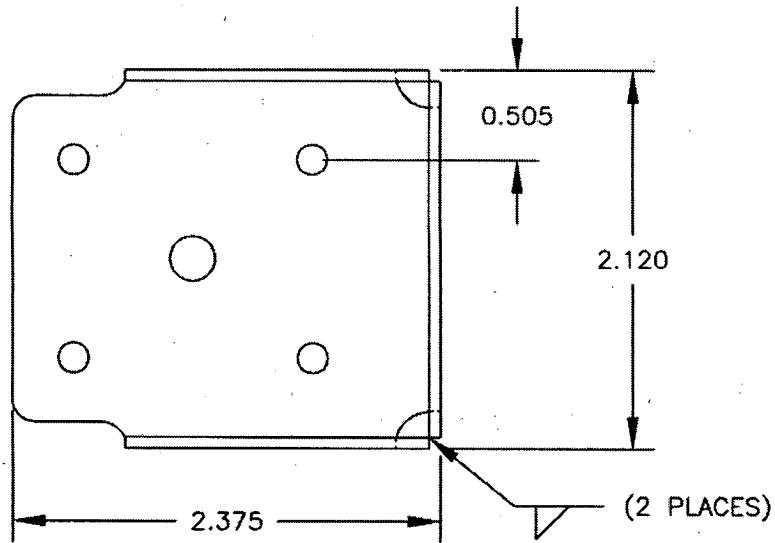
DART AEROSPACE LTD	Work Order:	41174
Description: Hinge Bracket	Part Number:	D2144
Inspection Dwg: D2144	Rev: D	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	13	Audited by:	✓	Prototype Approval:	N/A
Date:	8-8-21	Date:	08/08/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	<i>[Signature]</i>



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 WELD PER DART QSI 004

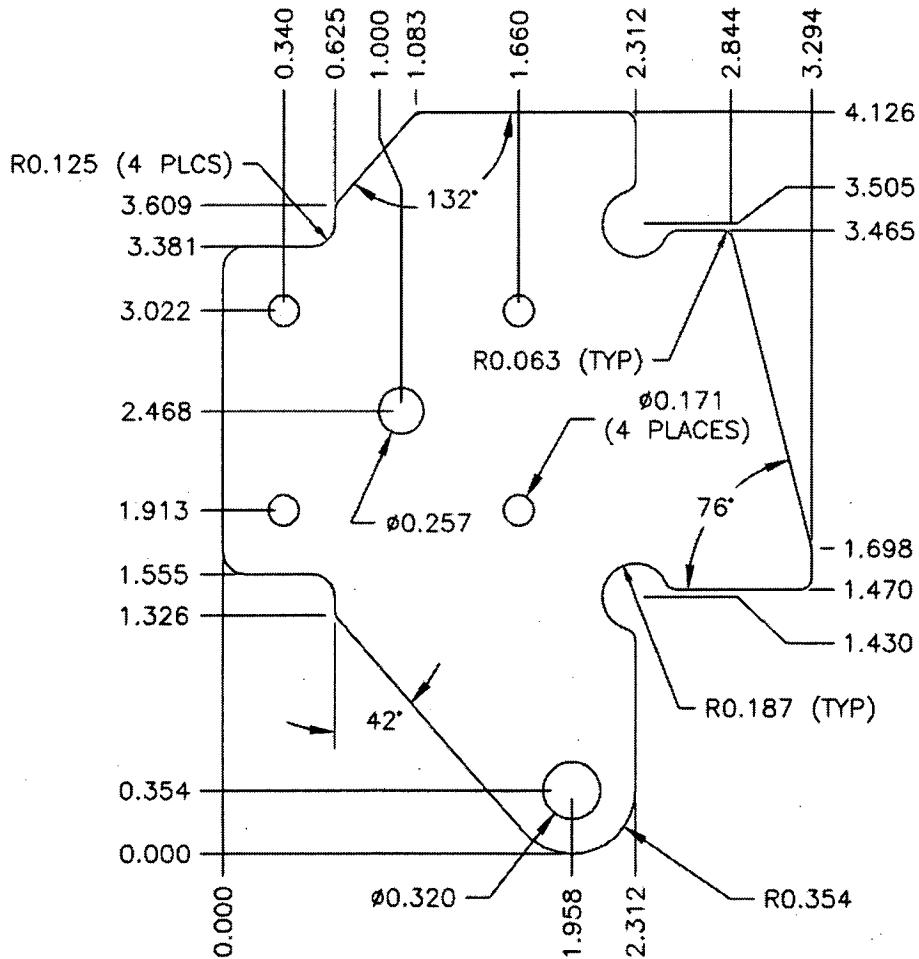
RELEASED  
 98.10.15  
 FG



DESIGN BY	DRAWN BY	DART AEROSPACE LTD
BW	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MF	J	D2144
DATE		SCALE
98.10.08		1:1
A	95.03.17	REV. D
C	96.06.05	SHEET 1 OF 2
D	98.10.08	UNCONTROLLED COPY
FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3		
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED		
WELD PER DART QSI 004		
SUBJECT TO AMENDMENT		
WITHOUT NOTICE		
WORK ORDER NO. 41174		

**DART**COPY IS  
MADE

DESIGN BW	DRAWN BY RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MH</i>	APPROVED <i>SP</i>	DRAWING NO. D2144
DATE 98.10.08	TITLE HINGE BRACKET	REV. D SHEET 2 OF 2 SCALE 1:1

**RELEASED**  
98.10.15 KGD2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED (1/1)

ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER